

SHIP 10/02

Dart Aerospace Ltd.

Date: Monday, 2/5/2007 10:45:31 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HINGE BRACKET
Job Number : 30635	
Estimate Number : 12543	
P.O. Number : N/A	Part Number : D35381
This Issue : 2/5/2007 S.O. No. : N/A	Drawing Number : D3538 REV.A
Prsht Rev. : NC	Project Number : 10254N/A
First Issue : N/A	Drawing Revision : A
Previous Run : 30206	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 2/12/2007
Checked & Approved By : <u>[Signature]</u> 07.02.05	Qty: 108 Um: 20 Each
Comment : Est Rev:A New Issue 06-10.03 EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1250X01250	6061-T6 Bar 1.25 x 1.25"
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2394



Comment: Qty.: 0.1995 f(s)/Unit Total : 3.9900 f(s)

6061-T6 Bar 1.250" x 1.250" (41)

Batch: M103220 32X

M18742 76X (9.5')

MB 07/02/08

108

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blanks 1.500" long

MB 07/02/08

108

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: 1-Machine as per Folio FA651 and Dwg D3538

2-Deburr

J.L. / MB / En 07/02/08

108

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L. / MB / En 07/02/08

108

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.F.

07/02/13 (108)

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1


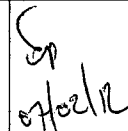
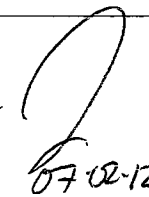
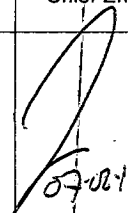
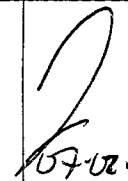
Chemical Conversion Coat as per QSI 005 4.1

M.B. / J.L.

07/02/14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/02/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/02/12	#3.0	6 parts scrap parts didn't set properly in vise Remach: use 5mm to fix. Problem	 07/02/12	Scrap holding and replace	 07/02/12	 07-02-12	 07-02-12	 07-02-12

NOTE: Date & initial all entries

Date: Monday, 2/5/2007 10:45:31 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 30635

Part Number: D35381

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

POWDER COATING

POWDER COATING



11/103141



(98)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-H/a.m

07/02/19

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

LC 7/2/20 108

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

5 LC 7/2/20 (1.8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(108)

Comment: FINAL INSPECTION/W/O RELEASE

07/02/22

Job Completion



U 07.02.22

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

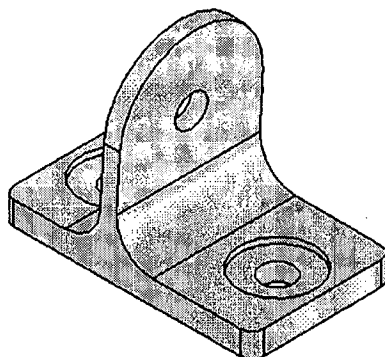
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

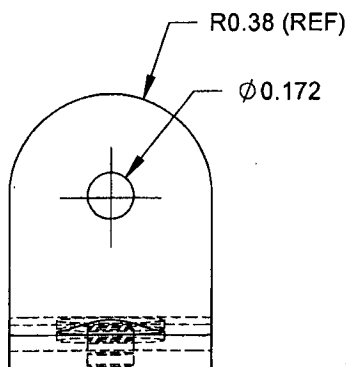
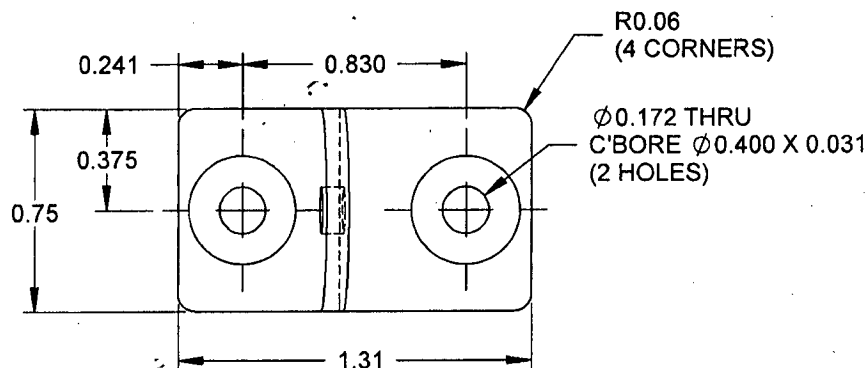
NOTE: Date & initial all entries



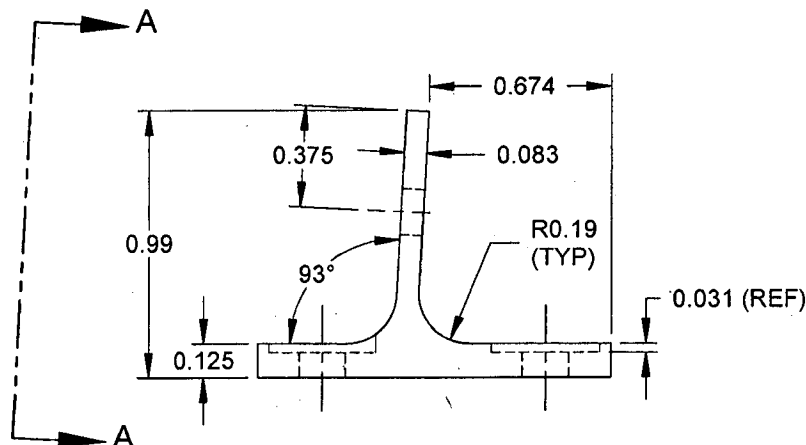
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3538	REV. A SHEET 1 OF 2
DATE 06.10.13	TITLE HINGE BRACKET		SCALE 1:1
REV A	DATE 06.10.13	DESCRIPTION NEW ISSUE	



RELEASED  
06.10.13



AUXILIARY VIEW A



D3538-1 HINGE BRACKET

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3538-1 USING FINE POINT PERMANENT INK MARKER

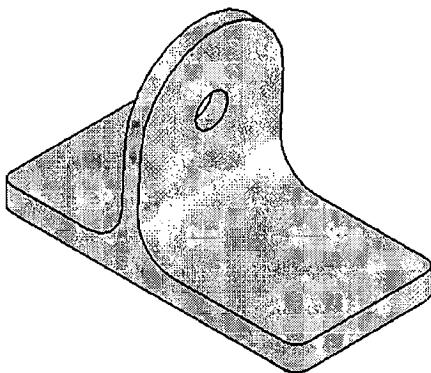
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WITHOUT NOTICE  
WORK ORDER  
NO. 30635

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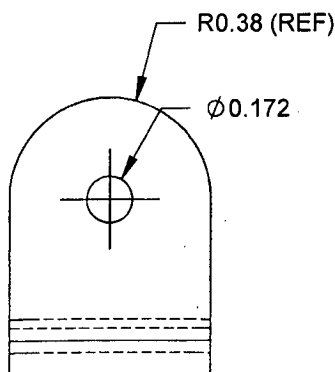
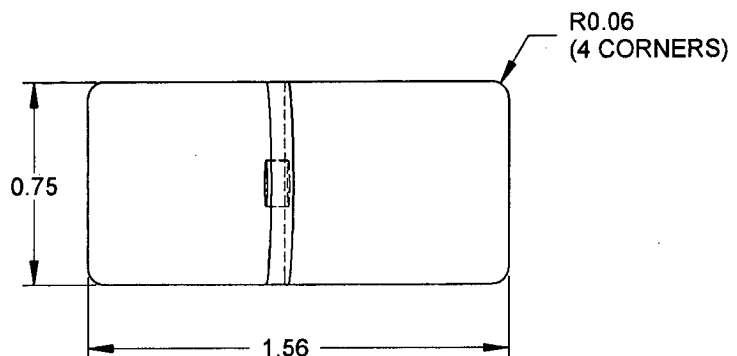
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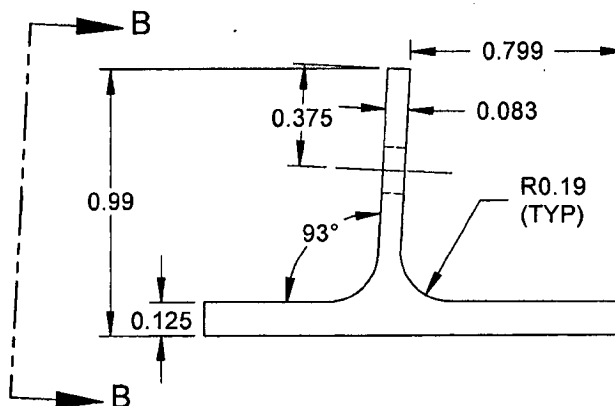
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3538</b>	REV. A SHEET 2 OF 2
DATE <b>06.10.13</b>		TITLE <b>HINGE BRACKET</b>	SCALE 1:1



RELEASED  
06.10.13



**AUXILIARY VIEW B**



**D3538-3 HINGE BRACKET**

**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3538-3 USING FINE POINT PERMANENT INK MARKER

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NO. **30635**

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<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 30635
<b>Description:</b> Hinge Bracket	<b>Part Number:</b> D3538-1
<b>Inspection Dwg:</b> D3538 , Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article     ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.241	$\pm 0.010$	.241	✓			
.830	$\pm 0.010$	.828	✓			
.375	$\pm 0.010$	.370	—			
1.31	$\pm 0.030$	1.315	✓			
.75	$\pm 0.030$	.75	✓			
.99	$\pm 0.030$	.991	✓			
.375	$\pm 0.010$	.375	✓			
93°	$\pm 1/2^\circ$	93°	✓			
.125	$\pm 0.010$	.125	✓			
.031	Ref	.033	✓			
R.19	$\pm 0.030$	0.200	—		R-G	
.830	$\pm 0.030$	0.829	✓			
.674	$\pm 0.010$	.670	✓			
R.38	$\pm 0.030$	0.375	—		R-G	
Ø.172	$\pm 0.005$	.173	✓			
Ø.172	$\pm 0.005$	0.175	—			

<b>Measured by:</b> MS/Er	<b>Audited by:</b> J.F.	<b>Prototype Approval:</b>
<b>Date:</b> 07/02/08	<b>Date:</b> 07/02/12	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

